User:

Wednesday, 15/09/2006

COSS Admin

**Process Sheet** 

**Drawing Name** 

Customer : CU-DAR001 Dart Helicopters Services

**Job Number** : 28495

**Estimate Number** : 11893 : NIA P.O. Number

This Issue

: 13/09/2006

S.O. No. : N/A

Prsht Rev. : NC : N/A First Issue **Previous Run** 

: N/A

: SMALL /MED FAB

Type

Checked & Approved By

D 02.04.15 Added dwg Rev.A1 NG

**Additional Product** 

Job Number:

Written By

Comment



Seq. #:

2.0

3.0

**Machine Or Operation:** 

Description:

304 RD Tube .500 x .035W

M304TR0500W035 1.0



Comment: Qty.:

BRAKE NC

3.1281 f(s)/Unit Total: 3.1281 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall

(M304TR0500W035)

Batch No: 17 101593

NC BRAKE

Comment: BRAKE NC

QC5

Punch tube 304/316 with 2B finish

Form as per dwg D2261

Deburr

INSPECT WORK TO CURRENT STEP



4.0

Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

5.0 QC3

Comment: INSPECT POWDER COAT

: MIRROR ARM LONG (S-76)

**Part Number** : D2261

**Drawing Number** : D2261 REV A1

**Project Number** : N/A **Drawing Revision** : NA Material

: 18/09/2006 **Due Date** 

Qty:

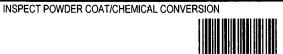
1 Um:

Each









## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						:	
Part No		PAR #: Fault Category:	NCP: Vo	s (No) DC	10.	Date: 0	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Ammanal	A			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
		•									
					-						

NOTE: Date & initial all entries

Date: Wednesday, 13/09/2006 8:59:20 AM COSS Admin User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: MIRROR ARM LONG (S-76) Job Number: 28495 Part Number: D2261 Job Number: Seq. #: Machine Or Operation: Description: D2022101 6.0 Spacer Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Spacer Pick: Qty Part Number Description Batch FF 06.09.14 D2022-101 Spacer A1449 7.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Grommet Pick: Qty Part Number Description Batch FF 06.09-14 Grommet M148 8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D2261 9.0 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U 560915 Job Completion

## Dart Aerospace Ltd

W/O:		WORK ORDER CI	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					<u> </u>			
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC	Corrective Action Section B			Varification		A		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
						,				

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

DART AERO ACCESSORIES INC TUBE DRAWING NO. L 01/4 M. Cohin. Aug 10/94

02227 S DIRECTOR AL 100- 0205.22 ADD FINISH DZZEI LONG TUBE DRAWN DESIGN

DLOIL-101 SPACER (2x) - AlthuA GROMMET

STANDARD FLARE

BOYTH RUBS (PARALLEL TO PLANE

OF BENDING)

ASSEMBLE PER DETAIL

GROWME

(2 LOCATIONS)

TUBE 30455 1/2" OD x . 035" WALL FOWDER CONT. BLACK SANDTEX (4.3.5.7)
PER DAKT ON OUT 4.3 A MATL: FINSH

## PROCEDURE:

- TOTAL TUBE LENGTH = 35,75" 1200
  - STANDARD FLAKE BUTH ENDS
- BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
  - FEED THRU II", BEND 90°
- FEED THRU 1934" (TOTAL), BEND 60°

257 Dia Both Ende

REFERENCE ONLY